

Date: Saturday, 04/04/2009 4:50:24 PM  
User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 46927		
Estimate Number	: 10393		
P.O. Number	:	Part Number	: D31461
This Issue	: 04/04/2009 S.O. No. :	Drawing Number	: D3146 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26709	Material	:
Written By	: <i>JLM</i> 04.04.09	Due Date	: 11/04/2009 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est A 04.04.28 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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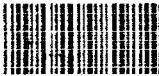
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25 X 4.50
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Comment: Qty.: 0.2932 f(s)/Unit Total : 2.3453 f(s)  
Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick  
(M6061T6B1.250x04.500)  
Batch: M109401

*88 09/04/04*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut blanks: 4.500" x 1.250" x 3.100" long Bar

*88 09/04/04*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA419 and Dwg D3146  
Identify as D3146-1

*PRO*  
*09/04/06 / 88 09/04/06*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*09/04/06 / 88 09/04/06*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*JL 09/04/06*



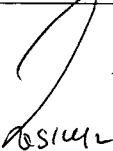


Comment: DEBURR & TUMBLE  
Deburr and Tumble

*N/A*  
*09/04/06*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3146-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 09/04/15  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 46927		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/06	3.0	2 parts are affected By thickness Too thin.  R.C. Jig problem, Jig fix By Machinist SS and Too get the part straight	 OSI/M	Scrap parts & try Qty 2 Modify & remark the Jig Fixture  Replace B 109401	SS 09/04/06 J.F.	 OSI/M	 OSI/M	

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46927

Part Number: D31461

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(X8)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LMO/ FL

09/04/07

8.0

POWDER COATING

POWDER COATING



m 110939

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:55

OVEN TEMPERATURE:

320°

FINISH TIME:

2:25

FL 09/04/08

(8)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect work to Step 9

FL 09/04/08 (8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

68

9/4/07

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 (8)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-09

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Bracket</b>		<b>Part Number:</b>	<b>D3146-1</b>
<b>Inspection Dwg: D3146</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

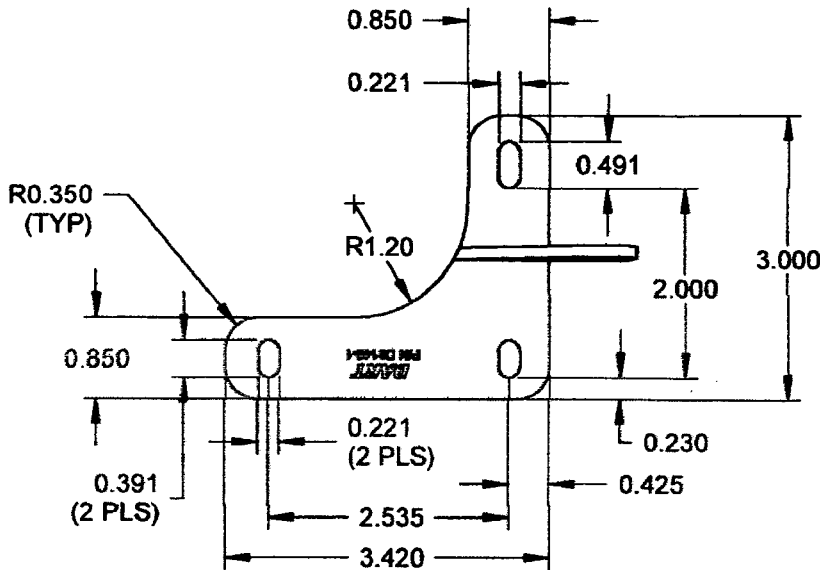
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.003	/			
2.000	+/-0.010	2.005	/			
0.230	+/-0.010	.233	/			
0.425	+/-0.010	.425	-			
3.420	+/-0.010	3.423	/			
2.535	+/-0.010	2.534	/			
0.221	+/-0.010	.222	/			
0.391	+/-0.010	.390	/			
0.221	+/-0.010	.222	/			
0.850	+/-0.010	.849	/			
R0.350	+/-0.010	.350	/			
0.850	+/-0.010	.851	/			
0.221	+/-0.010	.222	/			
0.491	+/-0.010	.488	/			
0.125	+/-0.010	.126	/			
1.025	+/-0.010	1.023	/			
R0.375	+/-0.010	.375	/			
28°	+/-0.5°	28°				
0.270	+/-0.010	.278	/			
0.920	+/-0.010	.930	/			
R0.125	+/-0.010	.125	/			
4.345	+/-0.010	4.345	/			
0.125	+/-0.010	.123	/			
93°	+/-0.5°	93°	/			
0.125	+/-0.010	.121	/			
Gram Dimension	N/A					

Inspected by: <i>SJS</i>	Accepted by: <i>JL</i>	Prototype Approval:	Rev:
Date: <i>09/04/06</i>	Date: <i>09/04/06</i>	Date:	N/A

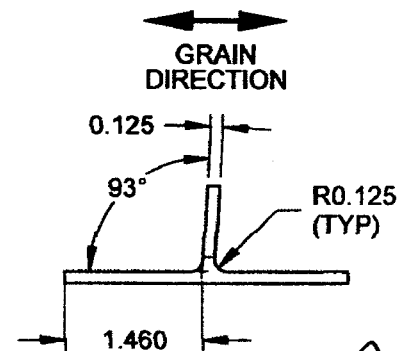
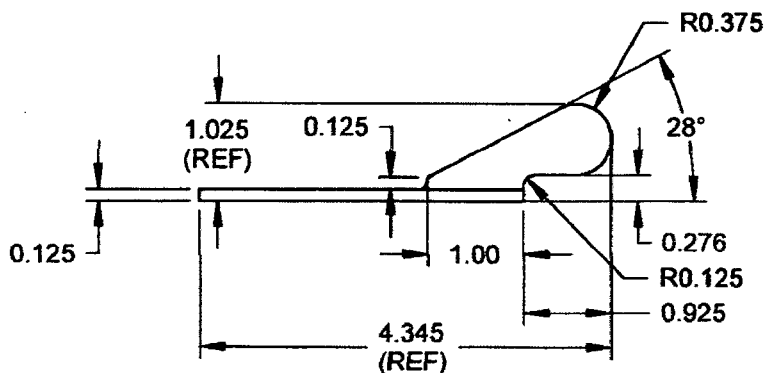


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3146	REV. B SHEET 1 OF 2
DATE 07.03.28	TITLE BRACKET		SCALE 1:2
REV	DATE	DESCRIPTION	
A	02.04.25	NEW ISSUE	
B	07.03.28	ADD -4, ROTATED LOGO AND P/N	



RELEASED

07.06.04



**D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27**  
**(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)**

**NOTES:**

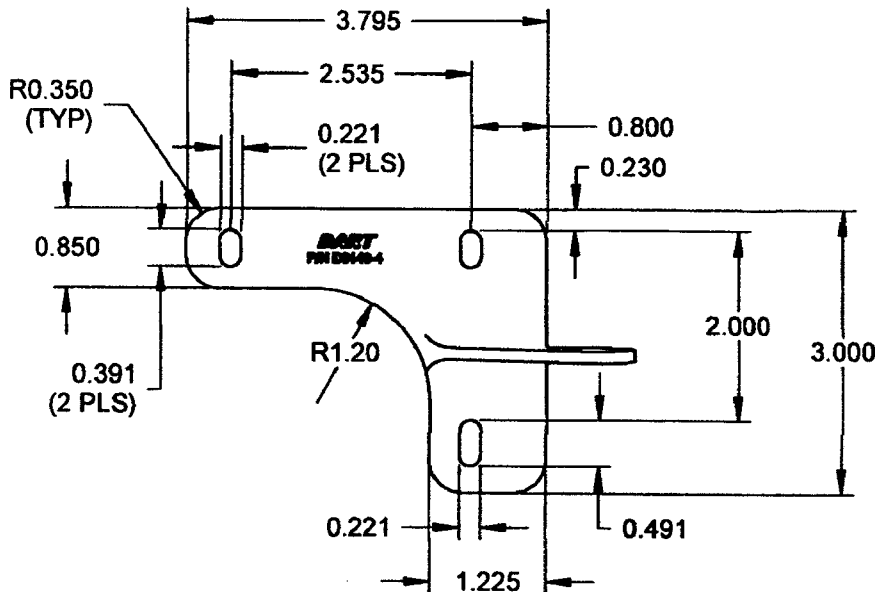
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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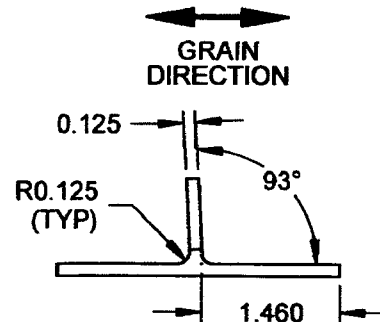
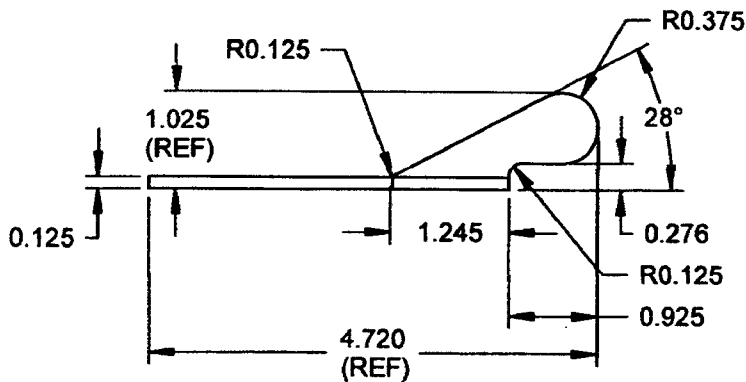
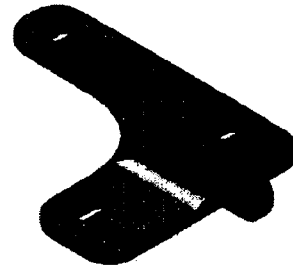


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3146	REV. B SHEET 2 OF 2
DATE 07.03.28	TITLE BRACKET		SCALE 1:2



RELEASED

07.06.04 #



46927

### D3146-4 BRACKET

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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